

Date: Wednesday, 12/21/2005 8:01:31 AM  
User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOUBLER		
Job Number	: 25339		Part Number	: D32831		
Estimate Number	: 11169		Drawing Number	: D3283 REV D		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 12/21/2005	S.O. No.	: N/A	Drawing Revision	: D	
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 12/28/2005 Qty: 50 Um: Each		
Previous Run	: N/A					
Written By	: See comment below					
Checked & Approved By	: See comment below					
Comment	: Est A 04.09.28 New issue KJ/JLM					

## Additional Product

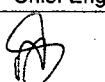
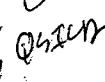
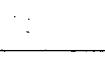
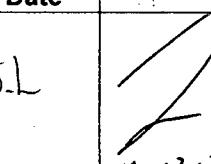
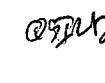
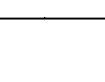
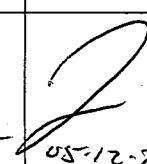
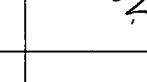
Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	M6061T6S063	6061-T6 .063 Sheet		
		Comment: Qty.: 0.2479 sf(s)/Unit Total : 12.3953 sf(s) 6061-T6 .063 Sheet Material: 6061-T6 (QQ-A-250/11) 0.063" thick (M6061T6S.063) Identify for D3283-1 Batch: M19326		SD 05.12.21 +10 En 05/21/21 50
2.0	SHEAR	SHEAR		
		Comment: SHEAR 15.000 Cut blanks: 15.550" <del>12.000"</del> 1.540.		SD 05.12.21 +10 En 05/21/21 50
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1		
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA424 and Dwg D3283 Stack of 10 Identify as D3283-1		JL 05.12.21 50
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE		
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE		JL 05.12.21 50
5.0	QC8	SECOND CHECK		
		Comment: SECOND CHECK		gml 05/21/21 50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/01/05  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05-12-21	3	- 1 stack of 10 scrap - error in pgm drilled only 4x2 holes instead of 5	  	- scrap + replace - pgm fixed	J.L  05-12-21	  	05-12-21	  

NOTE: Date & initial all entries

Date: Wednesday, 12/21/2005 8:01:31 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 25339

Part Number: D32831

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

FF 05/12/22

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Q 05/12/22

8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST

J 06-01-04

9.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SO

SP 06/01/05

Job Completion



Carl FP Acid Etch + Alodine

FF 05/12/22

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
05/02/22	6	Permanent change	W	05/02/22		U	

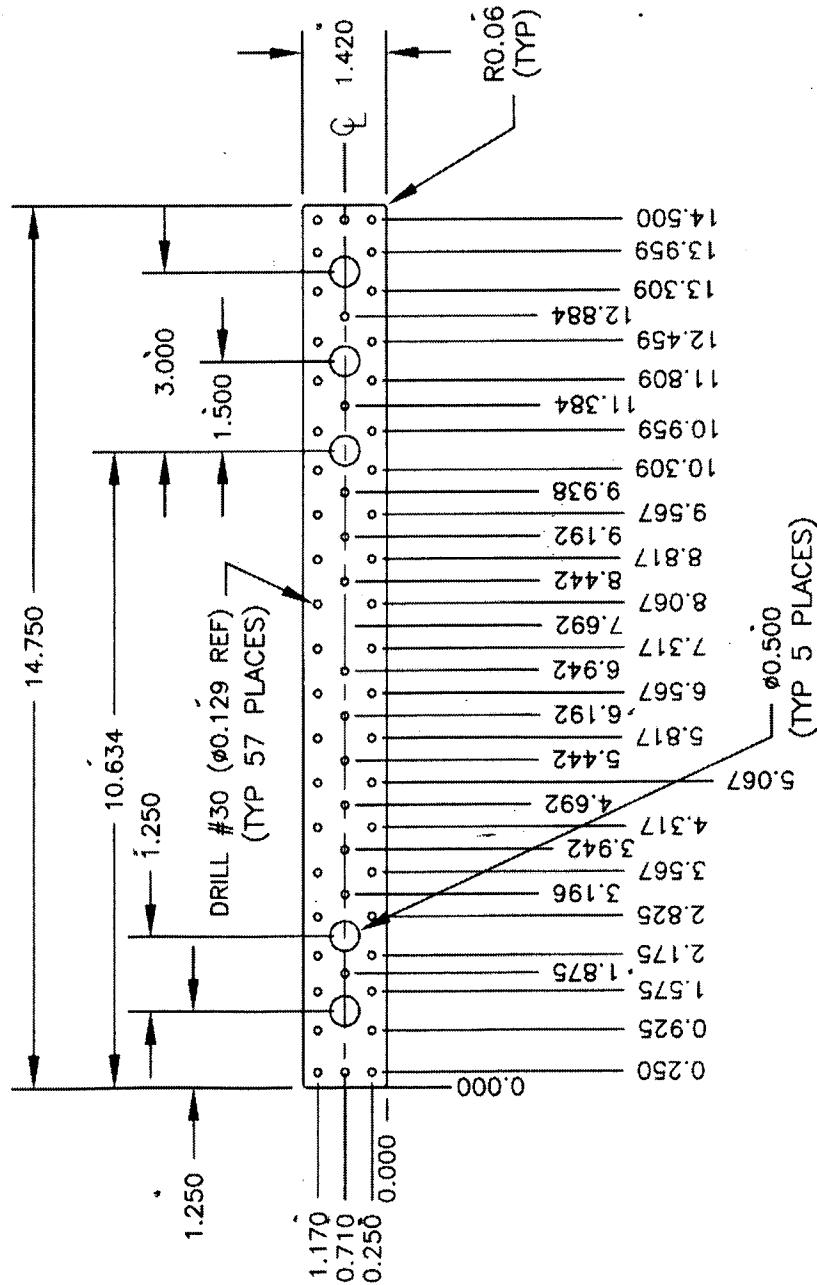
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE USA, INC.
CHECKED	<i>H</i>	APPROVED	<i>H</i>	PORT HADLOCK, WA
				REV. D
DATE			DRAWING NO.	SHEET 1 OF 2
05.08.09			D3283	
			TITLE	SCALE
			DOUBLER	1:3

RELEASED  
05.09.09 *H***D3283-1 DOUBLER**

- 1) MATERIAL: 6061-T6, 0.063 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.063).
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

Copyright © 2004 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

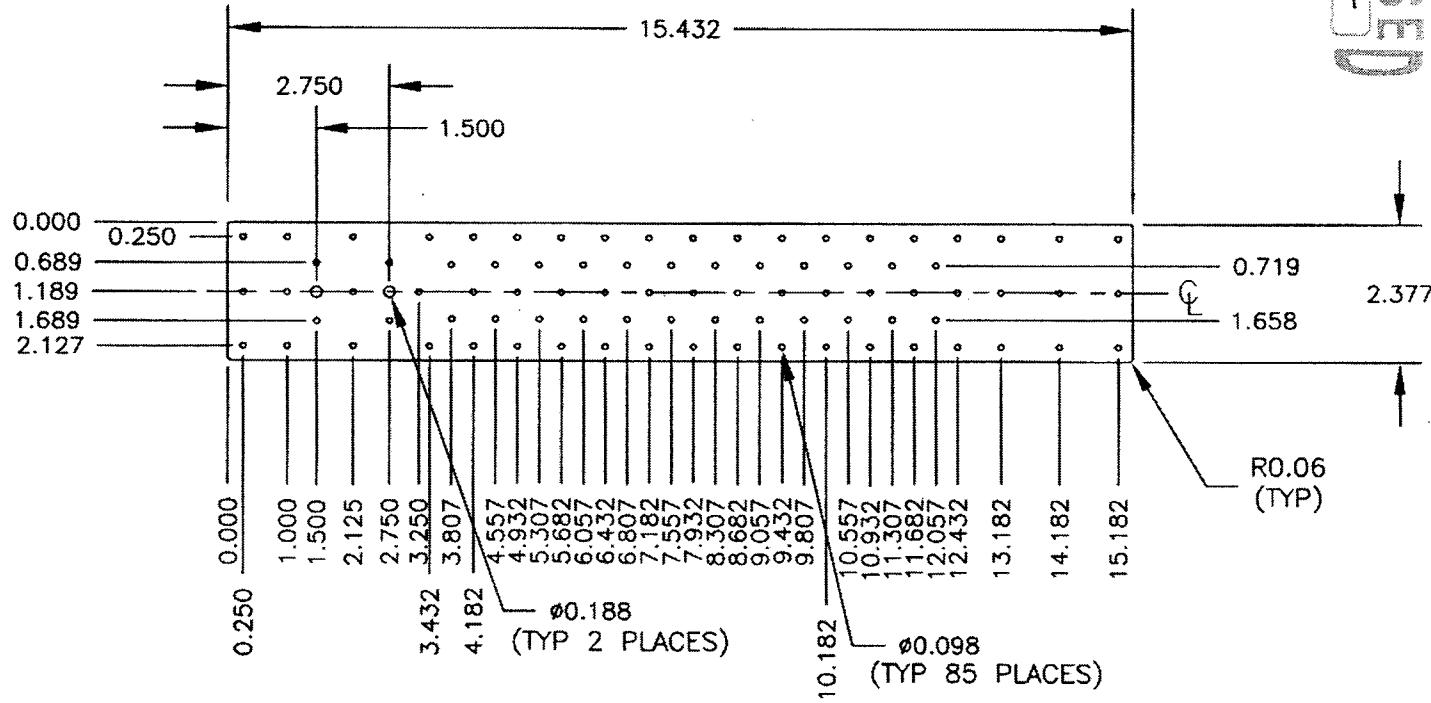
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

05.09.06  
H

EL ENS  
05.09.06

DESIGN	CP	DRAWN BY	CP	DART	AEROSPACE	USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	D3283	PORT HADLOCK, WA
DATE	05.08.09	TITLE	DOUBLER	SHEET	2 OF 2	REV. D
				SCALE		1:3



D3283-3 DOUBLER

- 1) MATERIAL: 6061-T6, 0.080 THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.080)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) ALL DIMENSIONS ARE IN INCHES

**Copyright © 2004 by DART AEROSPACE USA, INC.**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action      Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD

Work Order: 25339

Description: double

Part Number: D3283-1

Inspection Dwg: D3283 Rev: D

Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## First Article

1

## Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.750	+ .010	14.748	✓			
1.420	+ .010	1.422	✓			
1.250	+ .010	1.250	✓			
1.250	"	1.250	✓			
10.634	"	10.634	✓			
Ø.129	+ .005 -.001	.134	✓			
1.500	+ .010	1.499	✓			
3.000	"	2.999	✓			
5.060	"	.060	✓			
.250	"	.250	✓			
.710	"	.710	✓			
1.170	"	1.170	✓			
Ø.500	+ .004 -.001	.504	✓			
1.875	+ .010	1.875	✓			
6.192	"	6.192	✓			
2.175	"	2.175	✓			
4.317	"	4.317	✓			

Measured by:

71

Original article

1

#### Prototype Approval:

10

11A  
12A

Date

051221

Da

05/12/21

Date:

Rev  
A

Date

Change

#### Change

Revised by  
KURE

— 3 —